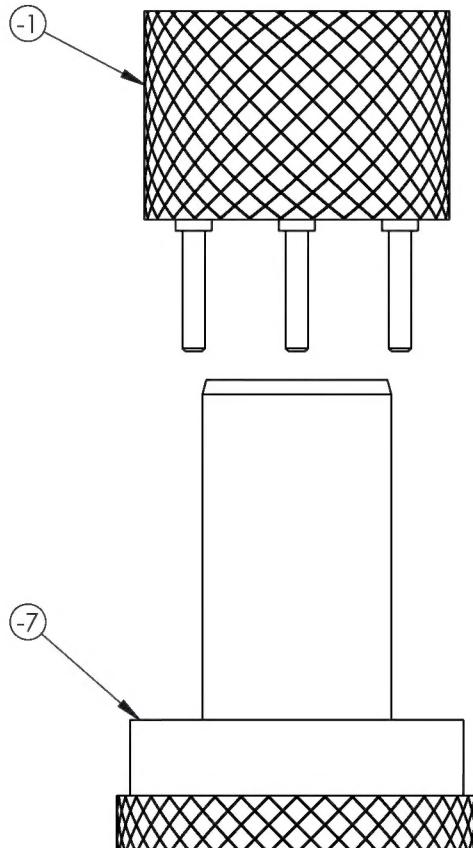


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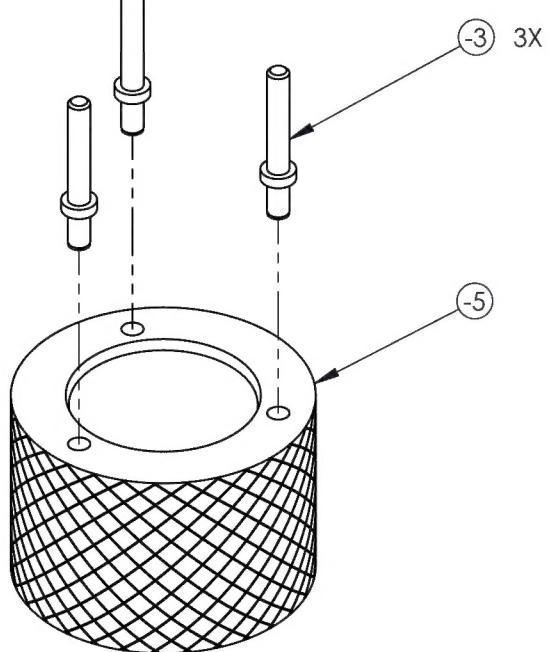
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D DIM. PRECISION FROM .XXX TO .XX ON NON-CRITICAL PARTS. REMOVED T/N'S FROM BOM. UPDATED TITLE BLOCKS. -3 ADDED .03 X 45° CHAMFER TO PRESS FIT PIN. -7 CH'D TO 1 PEICE WAS ASSY, DELETED -9 & -11.	10/17/2013	CFS	RW
2	-3 CH'D DIM WAS 1.260 IS 1.254, WAS .115 IS .118, ADDED CHAMFER WAS .03 X 45° IS 2X, .03 X 45°. -5 CH'D BOLT CIRCLE WAS Ø2.382 IS 2.479, ADDED .12 X 15° CHAMFER, ADDED R.031 MAX, ADDED ENGRAVE "RBW109-3130-70-111". -7 CH'D CHAMFER WAS .15 X 30° IS .15 X 15°, CH'D DIM'S WAS 3.93 IS 4.93, WAS 2.925 IS 3.93, WAS 2.515 IS 3.54, WAS Ø2.95 IS 2.954, ADDED 2X R.015 MAX.	4/17/2014		



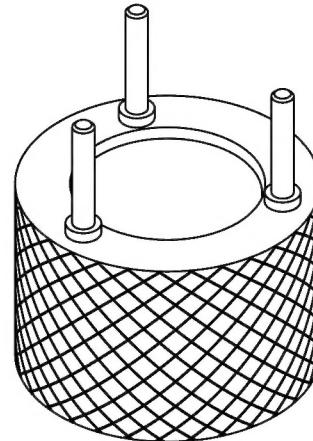
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
X			-1	1	BARREL ASSY			2
3			-3		PIN	4140 Q & T	Ø3/8 X 2	3
1			-5		BARREL	6061	Ø3-1/4 X 2-1/4	4
			-7	1	BASE	6061	Ø3-3/4 X 5-1/8	5
ASSY -1								

RED BARN MACHINE		REV
TITLE		TITLE
TAIL ROTOR PITCH CHANGE HOUSING		DUPLEX BEARING REMOVAL
DWG NO.		RBW109-3130-70-101
MATL	DRAWN BY:	GILBERT
UNLESS OTHERWISE SPECIFIED	APPROVED	D Weil
DIMENSIONS ARE IN INCHES		
.XXX ± .005	FRACTIONS ± 1/32	HEAT
.XX ± .01	ANGLES ± .5°	TREAT
.X ± .1		FINISH
1. BREAK ALL SHARP EDGES .015 X 45°	SPEC	
OR .015R	USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER		
PLATING	AW109	
SCALE	1:2	DATE
		4/5/2011
		SHEET 1 OF 5

REV		DESCRIPTION	DATE	INITIAL	APPROVED
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-1  
BARREL ASSY

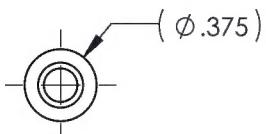
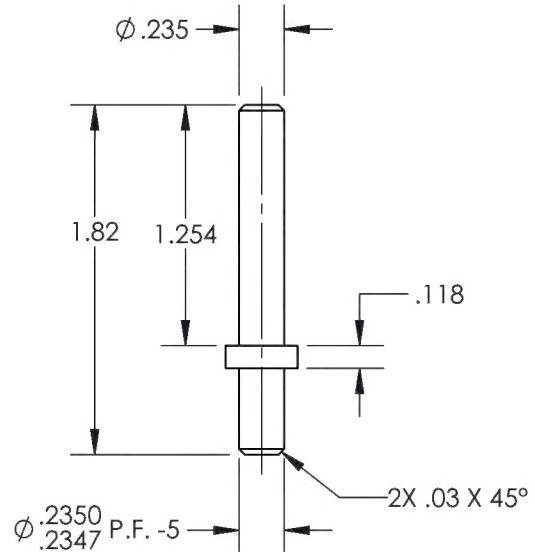


NOTE:  
1. PRESS 3 PINS INTO BARREL

	<b>RED BARN MACHINE</b>	REV <b>2</b>
<b>TITLE</b> TAIL ROTOR PITCH CHANGE HOUSING DUPLEX BEARING REMOVAL		
<b>DWG NO.</b>	<b>RBW109-3130-70-101-1</b>	
<b>MATL</b>	<b>DRAWN BY:</b> GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED	<i>D Weil</i>
.XXX ± .005	HEAT	
.XX ± .01	TREAT	
.X ± .1	FINISH	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL	
	AW109	
<b>SCALE</b>	1:2	<b>DATE</b> 3/30/2011
		<b>SHEET</b> 2 OF 5

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-3 ADDED .03 X 45° CHAMFER TO PRESS FIT PIN.	10/17/2013	CFS	RW
2	-3 CH'D DIM WAS 1.260 IS 1.254, WAS .115 IS .118. ADDED CHAMFER WAS .03 X 45° IS 2X .03 X 45°.	4/17/2014	RJC	DW



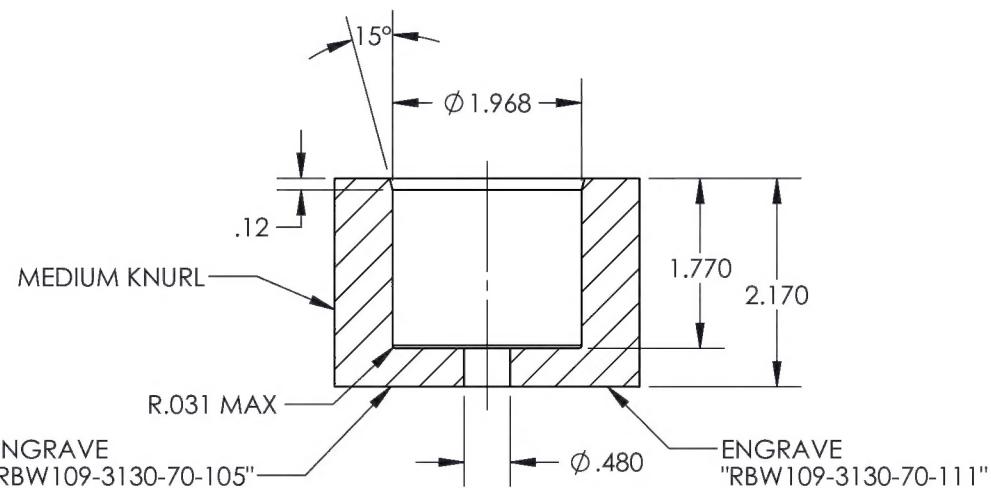
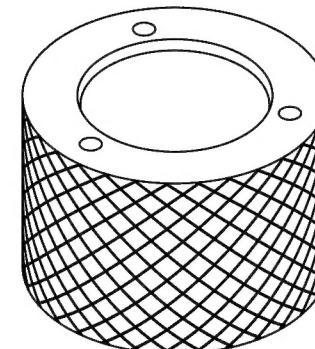
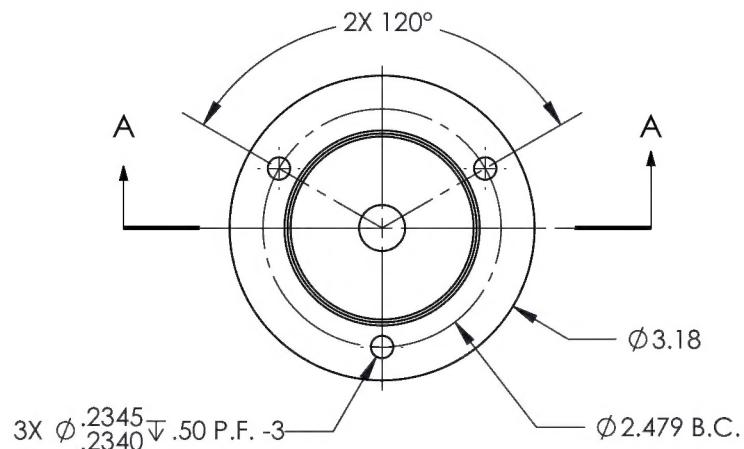
(-3)

PIN

	<b>RED BARN MACHINE</b>
TITLE	TAIL ROTOR PITCH CHANGE HOUSING DUPLEX BEARING REMOVAL
DWG NO.	RBW109-3130-70-101-3
MATL	4140 Q & T
UNLESS OTHERWISE SPECIFIED	DRAWN BY: GILBERT
DIMENSIONS ARE IN INCHES	APPROVED
.XXX ± .005	FRACTIONS ± 1/32
.XX ± .01	ANGLES ± .5°
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	HEAT TREAT FINISH CAD PLATE YELLOW
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC QQ-P-416F, TYPE II, CLASS II USED ON MODEL AW109
SCALE	1:1
DATE	3/30/2011
SHEET	3 OF 5

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	-5 CH'D BOLT CIRCLE WAS Ø2.382 IS 2.479, ADDED .12 X 15° CHAMFER, ADDED R.031 MAX, ADDED ENGRAVE "RBW109-3130-70-111".	4/17/2014	RJC	DW



SECTION A-A

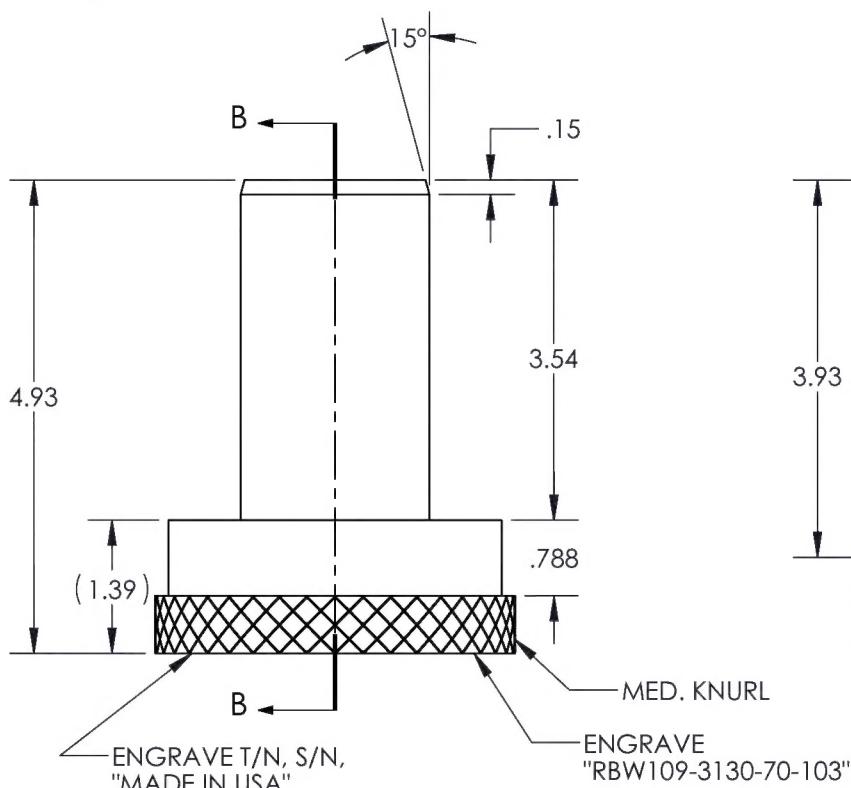
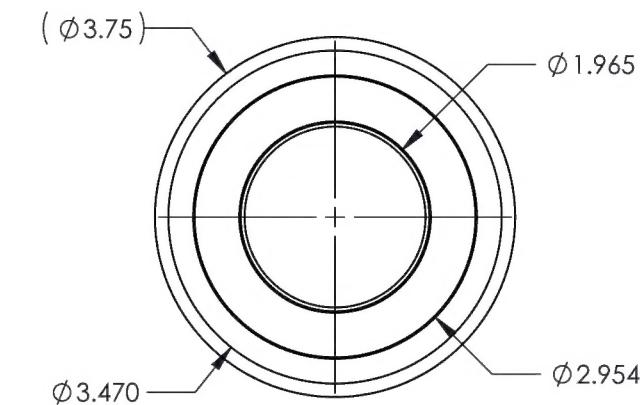
(-5)

BARREL

 RED BARN MACHINE	
TITLE TAIL ROTOR PITCH CHANGE HOUSING DUPLEX BEARING REMOVAL	
DWG NO.	RBW109-3130-70-101-5
MATL	6061
DRAWN BY:	GILBERT
APPROVED	<i>D Weil</i>
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005	FRACTIONS ± 1/32
.XX ± .01	ANGLES ± .5°
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
HEAT TREAT FINISH	CLEAR ANODIZE
SPEC MIL-A-8625F, TYPE II, CLASS I	
USED ON MODEL	
AW109	
SCALE	1:2
DATE	4/4/2011
SHEET 4 OF 5	

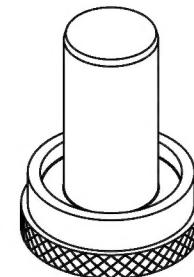
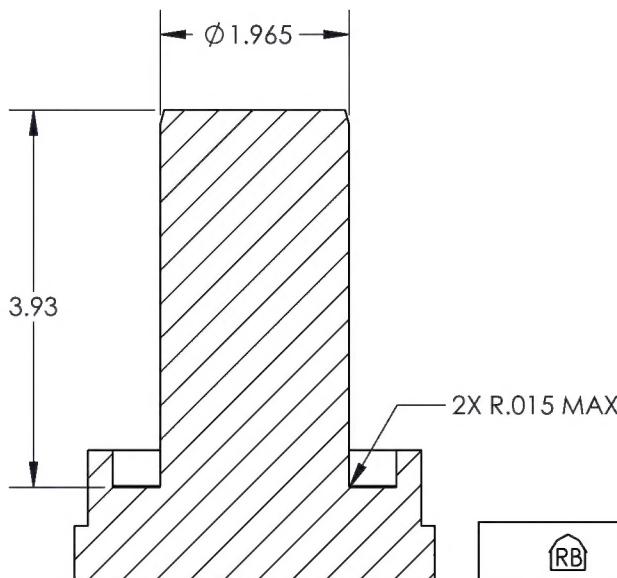
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REVISONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	-7 CH'D CHAMFER WAS .15 X 30° IS .15 X 15°, CH'D DIM'S WAS 3.93 IS 4.93, WAS 2.925 IS 3.93, WAS 2.515 IS 3.54, WAS Ø2.95 IS 2.954. ADDED 2X R.015 MAX.	4/17/2014	RJC	DW



(-7)

BASE



	<b>RED BARN MACHINE</b>
TITLE TAIL ROTOR PITCH CHANGE HOUSING DUPLEX BEARING REMOVAL	
DWG NO.	RBW109-3130-70-101-7
MAT'L	6061
DRAWN BY:	GILBERT
APPROVED	D Weil
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .005	FRACTIONS ± 1/32
.XX ± .01	ANGLES ± 5°
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC MIL-A-8625F, TYPE II, CLASS I
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	AW109
SCALE 1:2	DATE 3/25/2011
	SHEET 5 OF 5